

SPLIT 7

Work Order ID 52129 - 1

September 16, 2009 2:31:04 PM



Page 1

Item ID: D2917-2

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle RH

Start Date: 09/30/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/05/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-09-16 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2917

Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

SP 09/20/05

7

0

HAAS CNC vertical machine #1

Program batch number ☐ Machine Step No 1 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet ☐ Machine Step No 2 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet ☐ Machine Step No 3 as per Folio

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

SP 09/10/05

7

0

Conventional Milling Machine

Machine Keyway and inspect per Dwg D2917 & attached dimension sheet

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

SP 09/10/05

7

0

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

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Start Date: 09/30/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/05/2009 Req'd Qty: 10.00



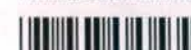
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

ml 09/10/06

7

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

09-10-6

(7)

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Bl 09-10-6

(7)

Powder Coating

START TIME: *8:50* ☐ OVEN TEMPERATURE:
320 ☐ FINISH TIME: *9:20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 52129

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Page 3

Item ID: D2917-2

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Setup Start



Revision ID: B

Stop



Item Name: Saddle RH

Start Date: 09/30/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/05/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

9/10/09 70 SR

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/10/09 70 SR

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/09

MF

09-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

September 16, 2009 2:31:04 PM

Page 1

Work Order ID: 52129



Parent Item: D2917-2RevB



Parent Item Name: Saddle RH

Start Date: 09/30/2009

Required Date: 10/05/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6102-010RevD		Manufactured	No			100	Each	6.0000	10.0000			
Saddle Billet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

6

51423

6

52067

8/8/09/10/05

70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 52129
Description: Saddle RH		Part Number: D2917-2
Inspection Dwg: D2917 Rev. A1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.175	0.205		.195	.197	.192	.195		
B	0.090	0.110		.095	.100	.100	.100		
C	0.250	0.270		.265	.267	.262	.267		
D	1.599	1.619		1.614	1.615	1.610	1.614		
E	0.180	0.220		.180	.180	.180	.180		
F	0.277	0.297		.285	.284	.288	.284		
G	1.385	1.400		1.391	1.395	1.390	1.390		
H	3.170	3.230		3.200	3.200	3.200	3.200		
I	0.175	0.217		.187	.184	.191	.191		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.503	1.503	1.503	1.503		
L	4.436	4.446		4.438	4.438	4.438	4.438		
M	0.257	0.262	DT8683	.259	.259	.259	.259		
N	1.225	1.235		1.228	1.228	1.228	1.228		
O	1.103	1.113		1.106	1.106	1.106	1.106		
P	0.470	0.530		.500	.500	.500	.500		
Q	0.438	0.443	DT8682	.440	.440	.440	.440		
R	0.490	0.510		.508	.502	.502	.500		
S	1.745	1.755		1.750	1.750	1.750	1.750		
T	7.990	8.010		8.000	8.000	8.000	8.000		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		.200	.200	.205	.200		
W	1.990	2.010		2.000	2.008	2.004	2.003		
X	0.760	0.765		.760	.760	.761	.761		
Y	0.307	0.312		.310	.310	.311	.311		
Z	0.615	0.635		.628	.624	.625	.625		
AA	0.177	0.197		.188	.185	.184	.185		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SP
Date:	09/10/05

Audited by:	SP
Date:	09/10/06

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 52129
Description: Saddle RH	Part Number: D2917-2
Inspection Dwg: D2917 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	4		
A	0.175	0.205		.186	.197	.196			
B	0.090	0.110		.100	.110	.110			
C	0.250	0.270		.258	.262	.263			
D	1.599	1.619		1.610	1.610	1.614			
E	0.180	0.220		.184	.180	.181			
F	0.277	0.297		.286	.285	.285			
G	1.385	1.400		1.390	1.392	1.393			
H	3.170	3.230		3.200	3.200	3.200			
I	0.175	0.217		.191	.175	.175			
J	0.470	0.530		.500	.500	.500			
K	1.498	1.508		1.503	1.503	1.503			
L	4.436	4.446		4.440	4.440	4.440			
M	0.257	0.262		.259	.259	.259			
N	1.225	1.235		1.230	1.230	1.230			
O	1.103	1.113		1.108	1.108	1.108			
P	0.470	0.530		.500	.500	.500			
Q	0.438	0.443		.440	.440	.440			
R	0.490	0.510		.500	.510	.505			
S	1.745	1.755		1.750	1.749	1.750			
T	7.990	8.010		8.000	8.000	8.000			
U	3.495	3.505		3.500	3.499	3.500			
V	0.175	0.205		.204	.205	.205			
W	2.000	2.020		2.000	2.004	2.000			
X	0.760	0.765		.760	.760	.760			
Y	0.307	0.312		.310	.311	.311			
Z	0.615	0.635		.625	.626	.628			
AA	0.177	0.197		.184	.185	.186			
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>SK</i>
Date: 09/09/05

Audited by: <i>SK</i>
Date: 09/09/06

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	
C	09.09.14	Revised dimension W	KJ	<i>SK</i>

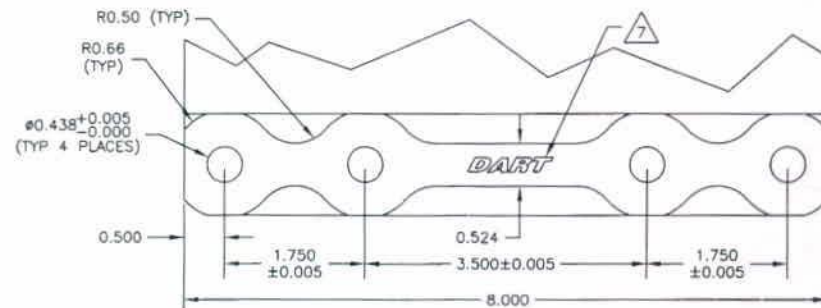
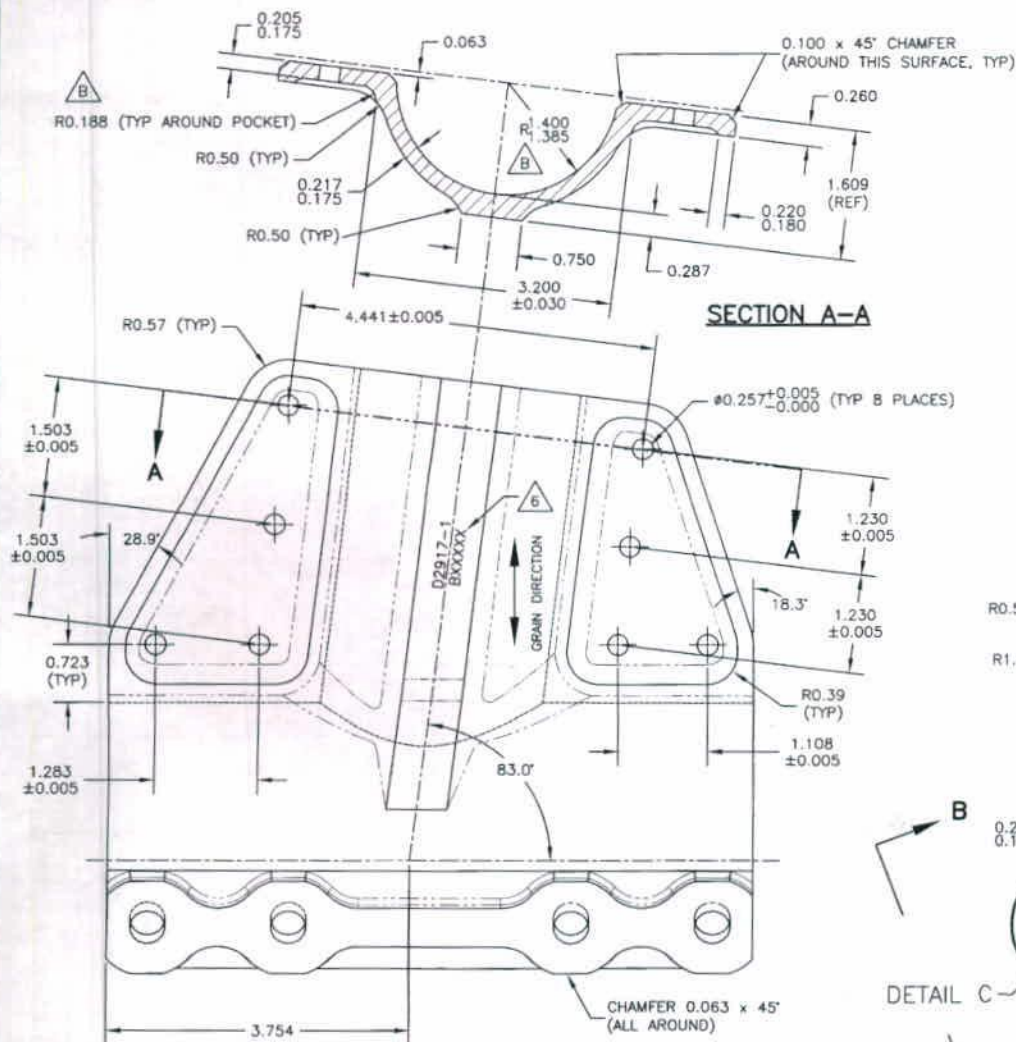
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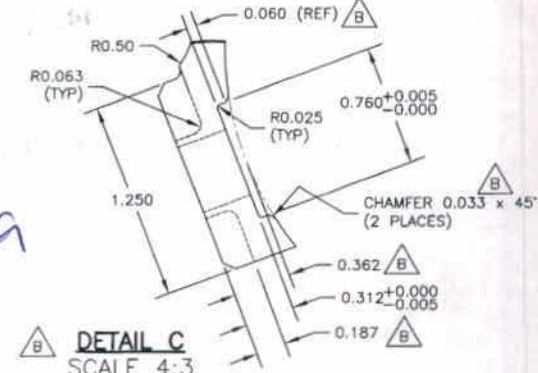
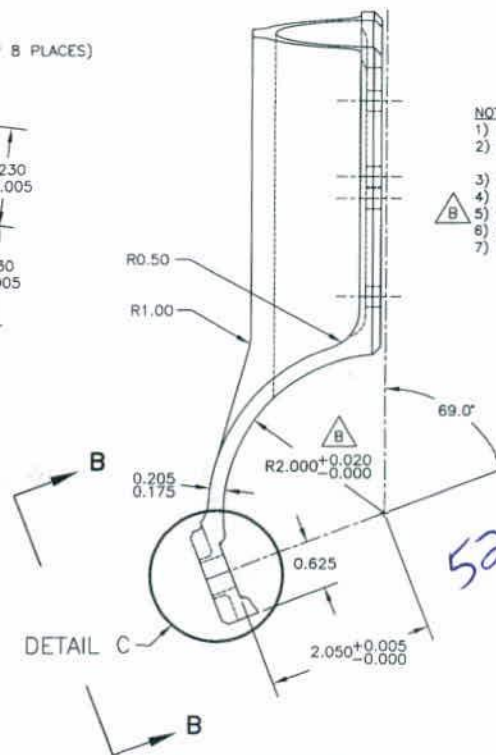
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D2917-1 LH SADDLE (SHOWN)
D2917-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 - 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



RELEASED

07.07.31

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

B	07.06.26	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	90	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.06.26	TITLE
		SADDLE
		DART AEROSPACE LTD. WARRICKSURY, OXFORD, ENGLAND
		REV. B SHEET 1 OF 1 SCALE 2:3

W/O:		WORK ORDER CHANGES					
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